

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012494**Date Inspected:** 04-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 12CW, weld No.CA3011-004. The welder is identified as #201215. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

SMAW in the 4F position for the OBG Segment 12CW, weld No.CA3011E-PP117-249/250. The welder is identified as #069896. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SAW in the 1G position for the OBG Segment 12CW, weld No.SEG3006*-005. The welder is identified as #045265. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG Segment 12BE, weld No.SEG3002*-006. The welder is identified as #044771. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2221-B-L2c-S-2.

During in process inspection the QA Inspector observed that the ZPMC Unqualified welder was performing welding on Corner Assembly at 2F position for Segment 12CW. After that the QA inspector inform to ZPMC Certified welding Inspector Mr. Gong Wai to remove that weld and do Magnetic Particle Testing to confirm the area is free from relevant indication then weld with qualified welder.

This QA Inspector did not generate any incident report for this date.

Witness of Magnetic Particle Testing

This Quality Insurance Inspector (QA) performed witness of Magnetic Particle Testing (MT) for OBG Cross Beam Bottom Plate temporary attachment removal area when the ZPMC QC MT technician performing MT. This QA inspector observed that the ZPMC MT technician found total four linear indications approximate 5mm to 14mm in length.

Y location for indications

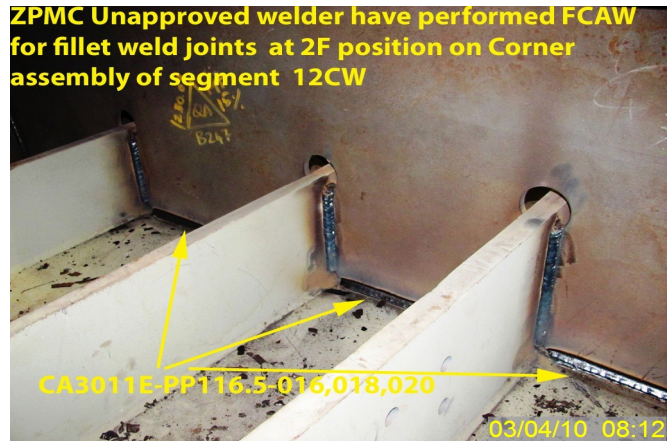
1st indication Y=6400mm from CB201A-006 Side plate and X=4600mm from west side of cross beam

2nd and 3rd indication Y=6670mm from CB201A-006 Side plate and X=1860mm from west side of cross beam

4th indication Y=3580mm from CB201A-006 Side plate and X=4680mm from west side of cross beam

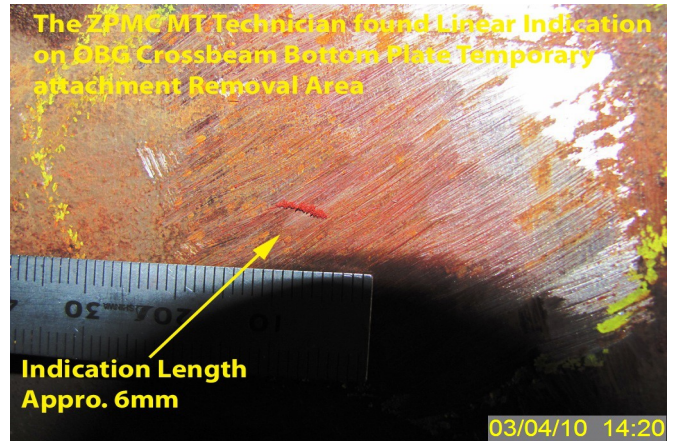
For details see the attached photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
